

Work Order ID 163374

Tuesday, June 27, 2017 11:34:21 AM

163374

Page 1

Item ID: D5152-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Fwd Post Mount
 Start Date: 7/13/2017 Start Qty: 8.00 ***8*** Cust Item ID:
 Required Date: 7/18/2017 Req'd Qty: 8.00 ***8*** Customer:
 Reference:

Approvals: Process Plan: DAS 21 9-89 Date: JUL 03 2017 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D5152	B								
110	FLOW WATER JET	0.00							
110									
Waterjet	Memo	0.12							
FLOW CNC Waterjet	1-Cut as per Dwg Dwg Rev: <u>B</u> Prog Rev: <u>B</u>								
120	QC2- Inspect parts off machine FAI/FAIB	0.00							
120									
QC	Memo	0.08							
Quality Control									
130	QC8- Inspect parts - second check	0.00							
130									
QC	Memo	0.16							
Quality Control									

8 SL 17/07/04
 DA: **45**
 9-8

8 SL 17/07/04
 DAS **45**
 9-89

8 DAS 38 9-89
 JUL 04 2017

Work Order ID 163374

Tuesday, June 27, 2017 11:34:21 AM

163374

Page 2

Item ID: D5152-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Fwd Post Mount

Start Date: 7/13/2017 Start Qty: 8.00

8

Cust Item ID:

Required Date: 7/18/2017 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

NR1

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
134		0.01							
134						8		DAS 19 9-89	MLL 17-7-17
Small Fab	Memo	0.43							
Small Fab	FROM USING DT10264 AS PER DWG								
136	QC5- Inspect part completeness to step on W/O	0.00				8			DAS 38 9-89
136									
QC	Memo	0.16							
Quality Control									
140	Identify as per dwg & Stock Location: _____	0.00							
140						8	JUL 17 2017	DAS 6 9-89	
Packaging	Memo	0.08							
Packaging	LOCATION: WA002								

Work Order ID 163374

Tuesday, June 27, 2017 11:34:21 AM

163374

Page 3

Item ID: D5152-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Fwd Post Mount

Stop ***NS2***

Start Date: 7/13/2017 Start Qty: 8.00

8

Cust Item ID:

Required Date: 7/18/2017 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC21- Final Inspection - Work Order Release

0.00

150

QC

Memo

0.80

Quality Control

DAS
21
9-89

JUL 1 8 2017

Picklist Print

Tuesday, June 27, 2017 11:34:18 AM

Page 1

Work Order ID: 163374

163374

Parent Item: D5152-1

D5152-1

Parent Item Name: Fwd Post Mount

Start Date: 7/13/2017

Required Date: 7/18/2017

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP REV:A 14.09.04 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S18GA		Purchased	No			110	sf	109.6099	0.09	0.757894			
M304S18GA									**				
304/316 .050 Sheet													

Location

Loc Qty

Loc Code

MAT020

108.8059

M135779

7.12

M136036

4.65

M136568

16.8959

M136687

2.24

M136790

13.9

M137481

64

MAT20

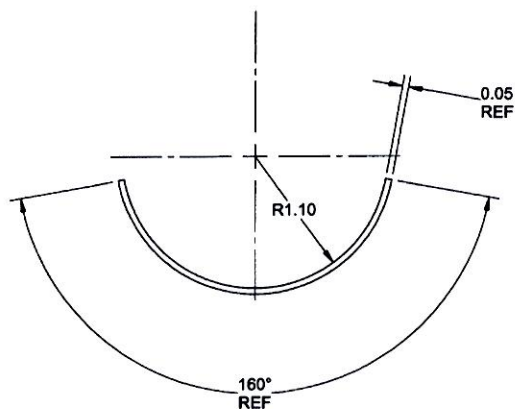
0.804

M134580

0.804

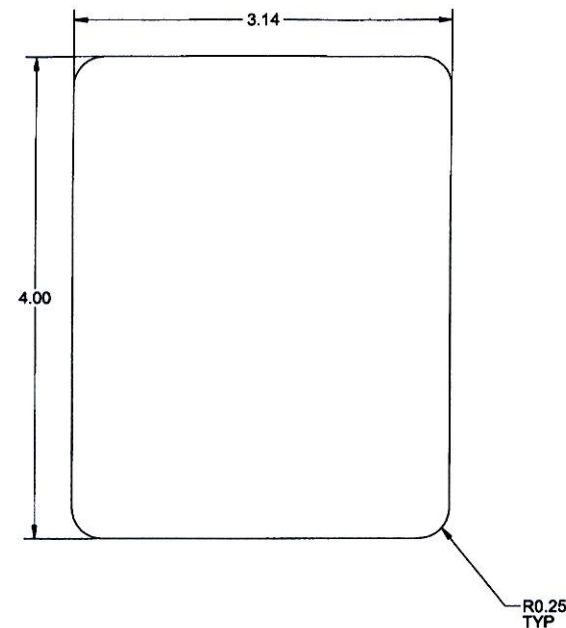
SC 17/07/04
DAS
45
9-89

8,76



D5152-1 FWD POST MOUNT
(MAKE FROM D5152-1F)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 163374 MCT
1707-03



D5152-1F FWD POST MOUNT
(FLAT PATTERN)

RELEASED

2015 FEB 09

- NOTES:
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER MIL-S-5059 OR AMS 5513 OR 5524 OR ASTM A240 OR ASME SA240, 0.050" THICK (PER DART SPEC M304S18GA)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: N/A

APPROVED

DESIGN	DB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	EPDMA		
CHECKED	DB	DRAWING NO.	REV. B
MFG. APPR.	DD	D5152	SHEET 3 OF 5
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	POST MOUNT	NTS
DATE	15.01.09	COPYRIGHT © 2014 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	